

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021977**Date Inspected:** 11-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

Bay 1

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 1 ZPMC was in process of welding weld repairs on Re-Built traveler rail assembly. ZPMC QC inspector ZHANG Ya Xu was present at this time of this observation and informed this QA inspector of the work that is in process. It was stated that ZPMC had 3 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

WR20369

Weld- 20TR2-044-015

WPS-345-SMAW-1G(1F)-Repair

Welder-054467

1G/CJP/SMAW

WR20368

Weld- 20TR2-036-011

WPS-345-SMAW-1G(1F)-Repair

Welder-049769

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

1G/CJP/SMAW

Weld- 20TR2-044-017

WPS-345-SMAW-1G(1F)-Repair

Welder-057795

1G/CJP/SMAW

Bay 11

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 11 ZPMC was in process of welding on West Tower Head Cover skin D. ZPMC QC inspector Mao Bin Bin was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. It was stated that ZPMC had 1 welder and identified the welder by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- WSD1-FDSA6-4-10 ~ 15

WPS-B-P-2112

Welder- 202354

2F/SMAW

Bay 10

This QA inspector performed a random observation for the OBG. During the observation performed it was noted that at Bay 10 ZPMC was in process of welding. ZPMC QC inspector Zhu Feng was present at this time of this observation and informed this QA inspector of the work that is in process and identified Xu Le Feng as the CWI. It was stated that ZPMC had 6 welders and identified the welders by ZPMC welder identification number appointed to then by ZPMC. This QA inspector verified this information for the following location;

Weld- NSD1-TL6-3 C/D-8

WPS-B-T2214-TC-U4b

Welder- 052493, 052930

4G/SMAW/CJP (Skin F)

UT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08518 from ZPMC for Bay 10. This QA inspector performed ultrasonic test (UT) verification for Item 1, after ZPMC had performed their UT inspection of the following locations.

Item 3

20TR2-039-009, 013, 015, 017, 011

This QA observed a Class "A" indication on weld 015. An IR was generated by this inspector for weld 015 not being within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 03-11-2011 for additional information.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Trial Assembly

MT Inspection

This Caltrans QA inspector received ZPMC non-destructive test (NDT) Inspection Notification, Doc. #08515 from ZPMC for Trial Assembly. This QA inspector performed visual and magnetic particle test (MT) verification for Item 3 after ZPMC had performed their MT inspection of the following locations;

Item 1

OBE12C-001

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Magnetic Particle Test Report (TL6028), dated 03-11-2011 for additional information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

“As noted within the contents of this report.”

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 1500026784, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Riley, Ken	QA Reviewer
